



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3372-7**Job Sheet 198809****Part No:** D3372-7**Job Qty:** 6 pcs**Part Name:** Slider Body**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/6/19**Job Tracking No:****Due Date:** 9/18/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV B IPP A 05.01.18 New issue KJ/JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	6 pcs		9/18/19	0.00	0.01	Bandsaw - 1		DAS 52 9-89 19-09-15
110	HAAS 4 Axis - B4B	6 pcs		9/18/19	1.00	2.28	HAAS - 1 - B4B		DAS 52 9-89 19-09-15
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	6 pcs		9/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		DAS 52 9-89 19-09-15
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

**Container No:** S213786**Part:** D3372-7**Job No:** 198809**Serial No/Batch:** S213786**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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CANADA
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Date: 09/16/19**PRIORITY**

Plex 8/6/19 1:53 PM Dart.lajeunesse.marie

				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	SEP 19-09-18
QC 8 - 25					
QC 8 - 3					
QC 8 - 32					
QC 8 - 33					
QC 8 - 35					
QC 8 - 39					
QC 8 - 4					
QC 8 - 44					
QC 8 - 45					
QC 8 - 49					
QC 8 - 58					
QC 8 - 8					
QC 8 - 9					
QC 8 - 68					
QC 8 - 67					
QC 8 - 1 (A)					
QC 8 - 47					
QC 8 - 40					
QC 8 - 52					
QC 8 - 23					
QC 8 - 57					
140 Handfinish - 1-1 Chemical- B4B	6 pcs	9/18/19	0.00 0.41	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	SEP 18 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Plex 8/6/19 1:53 PM Dart.lajeunesse.marie	

150 QC 7 M129223 6 pcs 9/18/19 0.00 0.00

START: 8:45 A.T: 3:30 FINISH: 9:15
152 - Powder Coat - 6 Fire Red B4B

155-QC3 DAS 81 9-89

DAS 35 9-89

DAS 35 9-89

Handfinish - 1 - 19 - B4B

Handfinish - 1 - 20 - B4B

Handfinish - 1 - 21 - B4B

Handfinish - 1 - 22 - B4B

QC 7 - 10

QC 7 - 13

QC 7 - 14

QC 7 - 15

QC 7 - 17

QC 7 - 18

QC 7 - 19

QC 7 - 2

QC 7 - 28

QC 7 - 3

QC 7 - 30

QC 7 - 34

QC 7 - 36

QC 7 - 37

QC 7 - 41

QC 7 - 47

QC 7 - 48

QC 7 - 51

QC 7 - 58

QC 7 - 59

QC 7 - 60

QC 7 - 9

QC 7 - 68

QC 7 - 50

QC 7 - 67

QC 7 - 40

QC 7 - 24

QC 7 - 43

QC 7 - 61

QC 7 - 81

DL 19-9-20.

160 Small Fab - 2 - B4B 6 pcs 9/18/19 0.00 3.50

Conv. Mill

DAS 35 9-89

Small Fab - 1 - B4B

Small Fab - 2 - B4B

Small Fab - 3 - B4B

Small Fab - 4 - B4B

Small Fab - 5 - B4B

Small Fab - 6 - B4B

Small Fab - 7 - B4B

Small Fab - 8 - B4B

Michel 2019-9-19

170 QC 5 / 2 DAS 35 9-89 6 pcs 9/18/19 0.00 0.00

175 QC8

DAS 35 9-89

DAS 23 9-89

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 68

QC 5 - 9

QC 5 - 23

19/9/23

					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
180 Powdercoat - 6 Fire Red - B4B	6	9/18/19	0.00 0.56		Powdercoat - 1 - B4B	
pcs					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
190 QC 3	6	9/18/19	0.00 0.00		QC 3 - 10	
pcs					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
200 Packaging 3-1 - Stock - B4B	6	9/18/19	0.00 0.00		Packaging 3 - 1 - B4B	
pcs					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	

15 min @ QC

DAS
81
9-89

SEP 20 2019

DAS
28
9-89

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210 QC 21 - SA	6	9/18/19	0.00 0.00	QC 21 - SA - 21		DAS
	pcs			QC 21 - SA - 70	SEP 23 2019	70
				QC 21 - SA - 53		9.89

Part Op 100 - Cut blank: 1.500" x 1.250" x 4.435" long
Descriptions: 110 - (HAAS CNC Vertical Machine), Machine D3372-7 as per Folio FA495 and Dwg D3372 Deburr
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - (Chemical Conversion Coat per QSI005 4.1), Chemical Conversion Coat per QSI005 4.1
 150 - QC7-Inspect Chemical Conversion Coat
 160 - Fabricate D3372-9 using AN6-36A bolt. Cut to length, then mill slot when bolt and D3372-7 are assembled as per Dwg D3372.
 170 - QC5- Inspect part completeness to step on W/O
 180 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3), START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 190 - QC3- Inspect Part Finish
 200 - Identify as per dwg & Stock Location: _____
 210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.250X1.500	6061-T6 Bar 1.250 X 1.500	2.2998 ft (.3833 ea)	100-Bandsaw - 1	S168970
AN6-36A	Bolt	6 Ea (1 ea)	160-Small Fab - 2 - B4B	S157483

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.250X1.500	2	20	0
160-Small Fab - 2 - B4B	AN6-36A	6	25	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 19880A
Description: Slider Body		Part Number: D3372-7
Inspection Dwg: D3372	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+/-0.005	0.750	✓		Ver	
0.313	+/-0.005	0.311	✓		Ver	
2.108	+/-0.010	2.107	✓		H.G.	
1.50	+/-0.030	1.505	✓		Ver	
0.63	+/-0.030	0.63	✓		Ver	
4.31	+/-0.030	4.314	✓		H.G.	
1.19	+/-0.030	1.193	✓		Ver	
0.613	+/-0.010	0.615	✓		Ver	
2.938	+/-0.010	2.938	✓		H.G.	
1.375	+/-0.010	1.376	✓		Ver	
0.200	+/-0.010	0.200	✓		Ver	
Ø0.323	+0.005/-0.000	Ø0.323	✓		G.P.	
0.500	+/-0.010	0.500	✓		Ver	
0.881	+/-0.010	0.881	✓		Ver	
1.400	"	1.400	✓		Ver	
0.390	"	0.390	✓		"	
R.0.188	"	R.0.188	✓		"	
0.195	"	0.195	✓		"	
0.200	+0.010 -0	0.201	✓		"	

Measured by: DAS 52 / 19/9/23	Audited by: DAS 20 / 9-89	Prototype Approval:	N/A
Date: 9-89 / 1909/15	Date: 19-09-18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	09.05.04	Dimensions revised	KJ/DD	

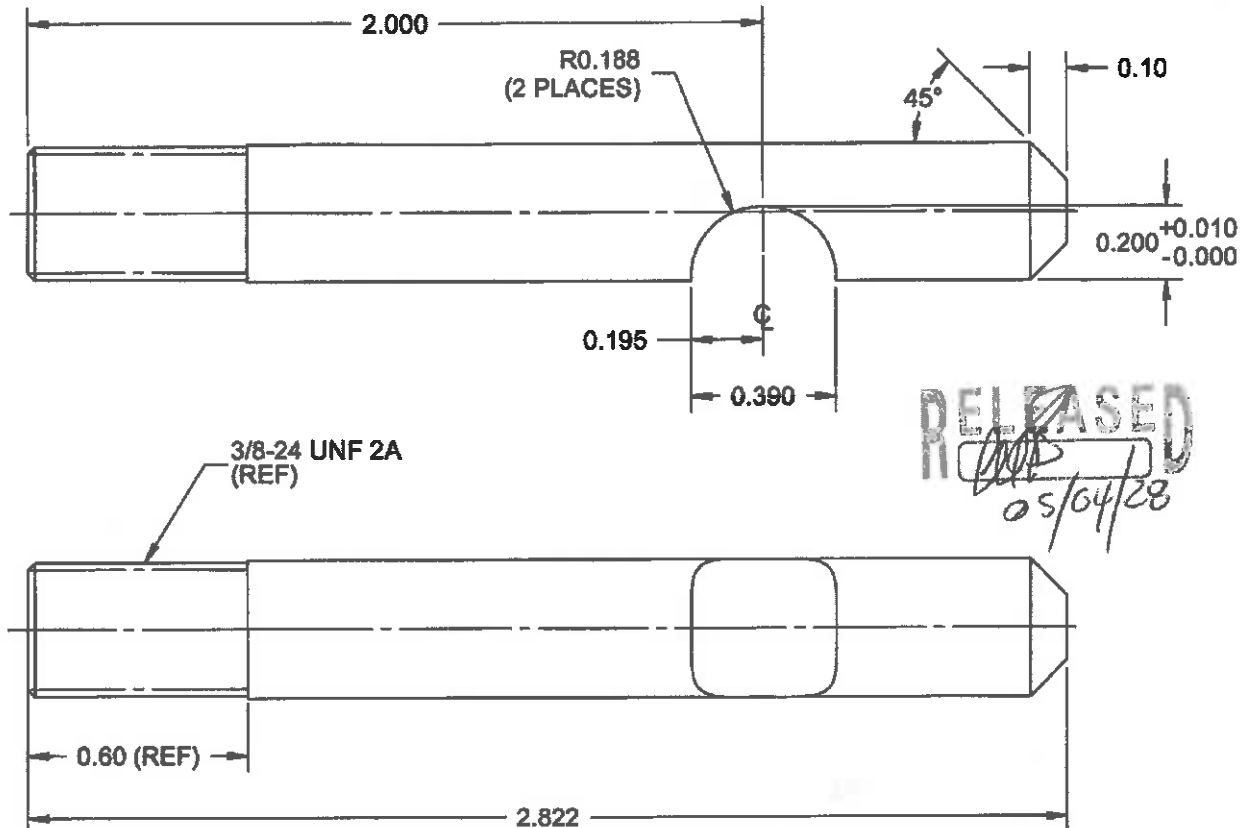
NCR No.

H:/FORMS/Quality Assurance/approved QA/NCRWO Rev J



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 8 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3372-9 LOCK GUIDE

NOTES:

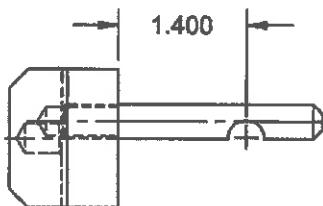
- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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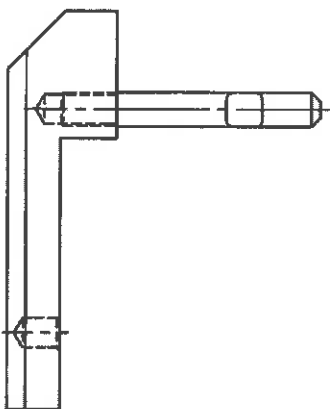
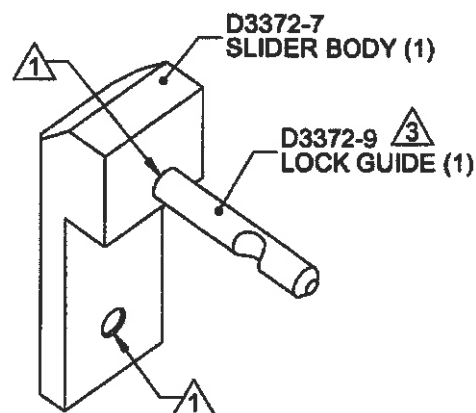
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 3 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2



RELEASED
[Signature]
05/04/23



D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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